

DART AEROSPACE LTD		Work Order:	22169
Description: Dual Disabling Device (Light Bell) BATTERY LOCK		Part Number:	D3369-041
		Keyed:	<input type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3369 Rev. A; D3370 Rev. A		Qty:	1
		Page 1 of 3	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Travelers for: <div style="display: flex; justify-content: space-between;"> D206-739-011 Dual Disabling Device Batch </div> <div style="display: flex; justify-content: space-between;"> D3369-1 Battery Lock Body </div> <div style="display: flex; justify-content: space-between;"> D3369-3 Cam Lock Shaft </div> <div style="display: flex; justify-content: space-between;"> D3370-1 Pedal Lock Base </div> <div style="display: flex; justify-content: space-between;"> D3370-3 Pedal Lock Cover </div> <div style="display: flex; justify-content: space-between;"> D3373-1 Cam Lock </div> <div style="display: flex; justify-content: space-between;"> D3373-5 Cam Lock </div> <div style="display: flex; justify-content: space-between;"> D3384-1 Cyclic Sock </div> <div style="display: flex; justify-content: space-between;"> D3385-1 Hinge </div>	JA	05.01.17	1																				
2	DC	Photocopy bluefile and create labels per PPP D206-739-011 CHG001		N/A	1																				
3	GA	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td></td> </tr> <tr> <td>1</td> <td>D3369-1</td> <td>Battery Lock Body</td> <td></td> </tr> <tr> <td>1</td> <td>D3369-3</td> <td>Cam Lock Shaft</td> <td></td> </tr> <tr> <td>1</td> <td>D3373-1</td> <td>Cam Lock</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3369-1	Battery Lock Body		1	D3369-3	Cam Lock Shaft		1	D3373-1	Cam Lock				
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3369-1	Battery Lock Body																							
1	D3369-3	Cam Lock Shaft																							
1	D3373-1	Cam Lock																							
4	GA	Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.																							
5	GA	Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5																							
6	GA	Assemble D3369-041 as per Dwg D3369. Insert lock body and fasten with lock body nut, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Apply a drop of permanent locktite 262 before threading D3369-3 shaft into lock, then install decal. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3369-5</td> <td>Washer</td> <td></td> </tr> <tr> <td>2</td> <td>5/16WC</td> <td>SS Flat Washer</td> <td></td> </tr> <tr> <td>A/R</td> <td>N/A</td> <td>Locktite 262</td> <td></td> </tr> </tbody> </table> Identify as D3369-041 and attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	1	D3369-5	Washer		2	5/16WC	SS Flat Washer		A/R	N/A	Locktite 262								
Qty	Part Number	Description	Batch																						
1	D3369-5	Washer																							
2	5/16WC	SS Flat Washer																							
A/R	N/A	Locktite 262																							
7	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask Dowel Pins Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3370-1</td> <td>Pedal Lock Base</td> <td></td> </tr> <tr> <td>1</td> <td>D3370-3</td> <td>Pedal Lock Cover</td> <td></td> </tr> <tr> <td>1</td> <td>D3385-1</td> <td>Hinge</td> <td></td> </tr> </tbody> </table> Identify as D3370-051	Qty	Part Number	Description	Batch	1	D3370-1	Pedal Lock Base		1	D3370-3	Pedal Lock Cover		1	D3385-1	Hinge								
Qty	Part Number	Description	Batch																						
1	D3370-1	Pedal Lock Base																							
1	D3370-3	Pedal Lock Cover																							
1	D3385-1	Hinge																							
8	QC3	Inspect Powder Coat																							

RELEASED
05.01.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22169
Description: Dual Disabling Device (Light Bell) BATTERY LOCK		Part Number:	D3369-041 D206-739-011
Dwg: D3369 Rev. A; D3370 Rev. A		Keyed:	<input type="checkbox"/> Alike <input type="checkbox"/> Unlike
		Qty:	1
Page 2 of 3			

Step	Location	Procedure	By	Date	Qty																				
9	GA	Press dowel pins into D3370-3 pedal lock cover, then assemble hinge as per Dwg D3370 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td></td> </tr> <tr> <td>1</td> <td>D3373-5</td> <td>Cam Lock</td> <td></td> </tr> <tr> <td>4</td> <td>AN526C832R</td> <td>Screw</td> <td></td> </tr> <tr> <td>3</td> <td>N/A</td> <td>Ø3/16" Dowel Pin 1/2" long</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3373-5	Cam Lock		4	AN526C832R	Screw		3	N/A	Ø3/16" Dowel Pin 1/2" long				
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3373-5	Cam Lock																							
4	AN526C832R	Screw																							
3	N/A	Ø3/16" Dowel Pin 1/2" long																							
10	GA	Open D3373-5 lock package. Keep keys, lock body, lock body nut, screw, offset cam and lock barrel. Discard the rest.																							
11	GA	Fabricate D3373-5 Cam Lock as per Dwg D3370 Identify as D3373-5																							
12	GA	Assemble lock mechanism and cam and install decal as per Dwg D3370																							
13	GA	Assemble lanyard to cyclic sock as per Dwg D3384 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3384-1</td> <td>Cyclic Sock</td> <td></td> </tr> <tr> <td>2</td> <td>CBL-460</td> <td>Loop Sleeve</td> <td></td> </tr> <tr> <td>28"</td> <td>CBL-1240</td> <td>Cable</td> <td></td> </tr> </tbody> </table> Identify as D3384-041	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock		2	CBL-460	Loop Sleeve		28"	CBL-1240	Cable								
Qty	Part Number	Description	Batch																						
1	D3384-1	Cyclic Sock																							
2	CBL-460	Loop Sleeve																							
28"	CBL-1240	Cable																							
14	GA	Assemble D3384-041 to D3370-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3370. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN960-416</td> <td>Washer</td> <td></td> </tr> <tr> <td>1</td> <td>HX-81</td> <td>1/4"-20 SHCS 3/8" long</td> <td></td> </tr> </tbody> </table> Identify as D3370-041 & attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	2	AN960-416	Washer		1	HX-81	1/4"-20 SHCS 3/8" long												
Qty	Part Number	Description	Batch																						
2	AN960-416	Washer																							
1	HX-81	1/4"-20 SHCS 3/8" long																							
15	QC5	Inspect work to Step 14/6																							
16	PK	Ensure that keys are attached to D3369-041 and D3370-041 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3369-041</td> <td>Battery Lock Assembly</td> <td>B22169</td> </tr> <tr> <td>1</td> <td>D3370-041</td> <td>Pedal Lock Assembly</td> <td>N/A</td> </tr> </tbody> </table> Ensure that keys can be locked and unlocked for each D3369-041 and D3370-041 assembly.	Qty	Part Number	Description	Batch	1	D3369-041	Battery Lock Assembly	B22169	1	D3370-041	Pedal Lock Assembly	N/A	CL	05/01/19	1								
Qty	Part Number	Description	Batch																						
1	D3369-041	Battery Lock Assembly	B22169																						
1	D3370-041	Pedal Lock Assembly	N/A																						
17	QC4	Inspect Kit 100% for Completeness on the W/O	U	05/01/19	1																				
18	PK	Identify and pack for shipping as per PPP D206-739-011 STOCK D3369-041 RETRY	CL	05/01/19	1																				
19	AC	Cost / part: _____																							
20	DC	Close W/Order and Ensure Travelers Attached Inspect Level 21 Travelers: D206-739-011 D3369-1 / D3369-3 D3370-1 / D3370-3 D3373-1 / D3373-5 D3384-1 / D3385-1		05.01.24	1																				

N/A
05.01.17

RELEASED
05.01.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 12, 2005
01:18 pm

Work Order No : 0022169
Project Name : D3369-041
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : D3369-041
Description : Battery Lock
Manufactured : No
Amount Req'd : 0
Amount Done : 0
Start Date :
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00